

Work Order ID 132552

May-07-15 2:55:53 PM

132552

Page 1

Item ID: D4355-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bearpaw

Stop ***NS2***

Start Date: 5/07/15 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 5/07/15 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4355	B

120 0.00

120

FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

Cut Blank as per D4355-1 File

UHMW 1"

2 Ø JM15-5-14

130 0.00

130

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining

2-Machine as per FolioFB049 and Dwg

FOLIO REV: AA

DWG REV: B

3-Deburr

2 Ø JH 2015-05-27
WJP
15/05/20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : _____							

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JUN 01 2015

DQA: _____ Date: _____



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Work Order update only ☐

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Work Order ID 132552***132552***

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May-07-15 2:55:53 PM

Item ID: D4355-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bearpaw

Stop ***NS2***

Start Date: 5/07/15 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/07/15 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

15/6/2
ME
5-6-2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Page 1

Work Order ID: 132552

132552

Parent Item: D4355-1

D4355-1

Parent Item Name: Bearpaw

Start Date: 5/07/15

Required Date: 5/07/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-04-11 JLMN VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	575.3420	5.3	12			
MUHMWB10									**		Jm15-5-14		
UHMW 1" Black - 48"x120" Tivar Mfg.#52480104													

Location

Loc Qty

Loc Code

MAT

519.475

m131661

119.475

m132063

400

MAT018

55.867

m131335

55.867

131661

DQA: _____ Date: _____

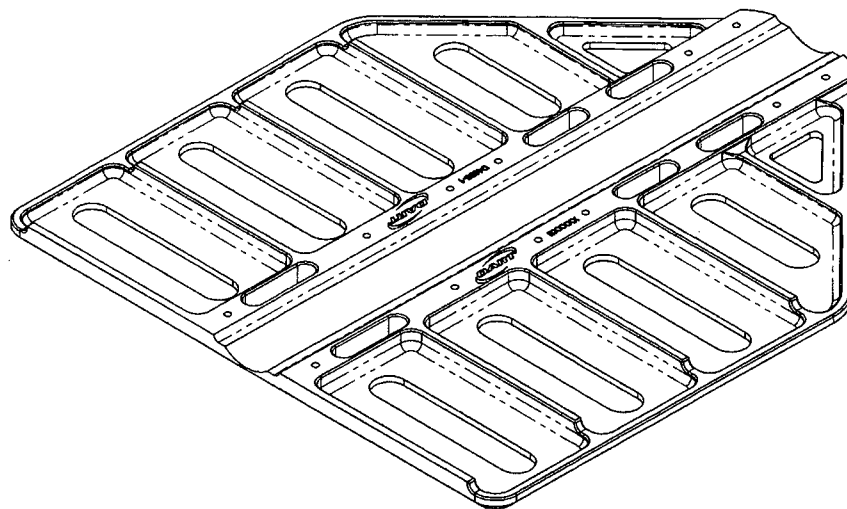


WORK ORDER NON-CONFORMANCE / UPDATE

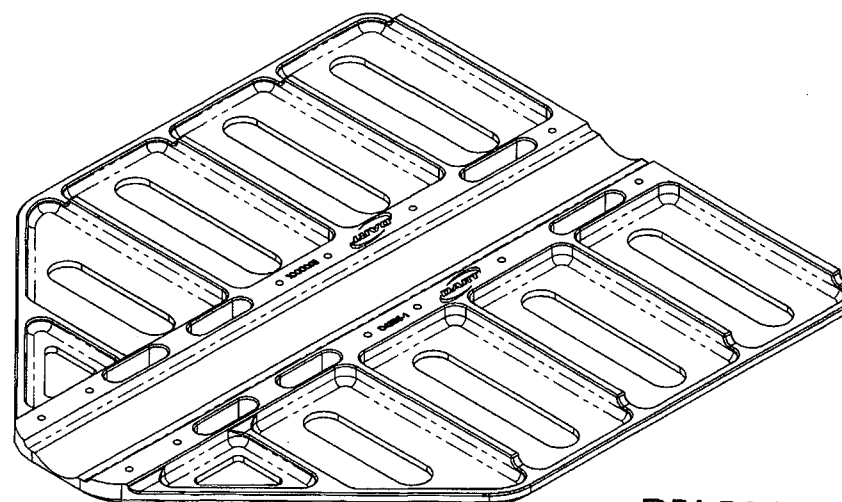
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D4355-1 206L/407 BEARPAW



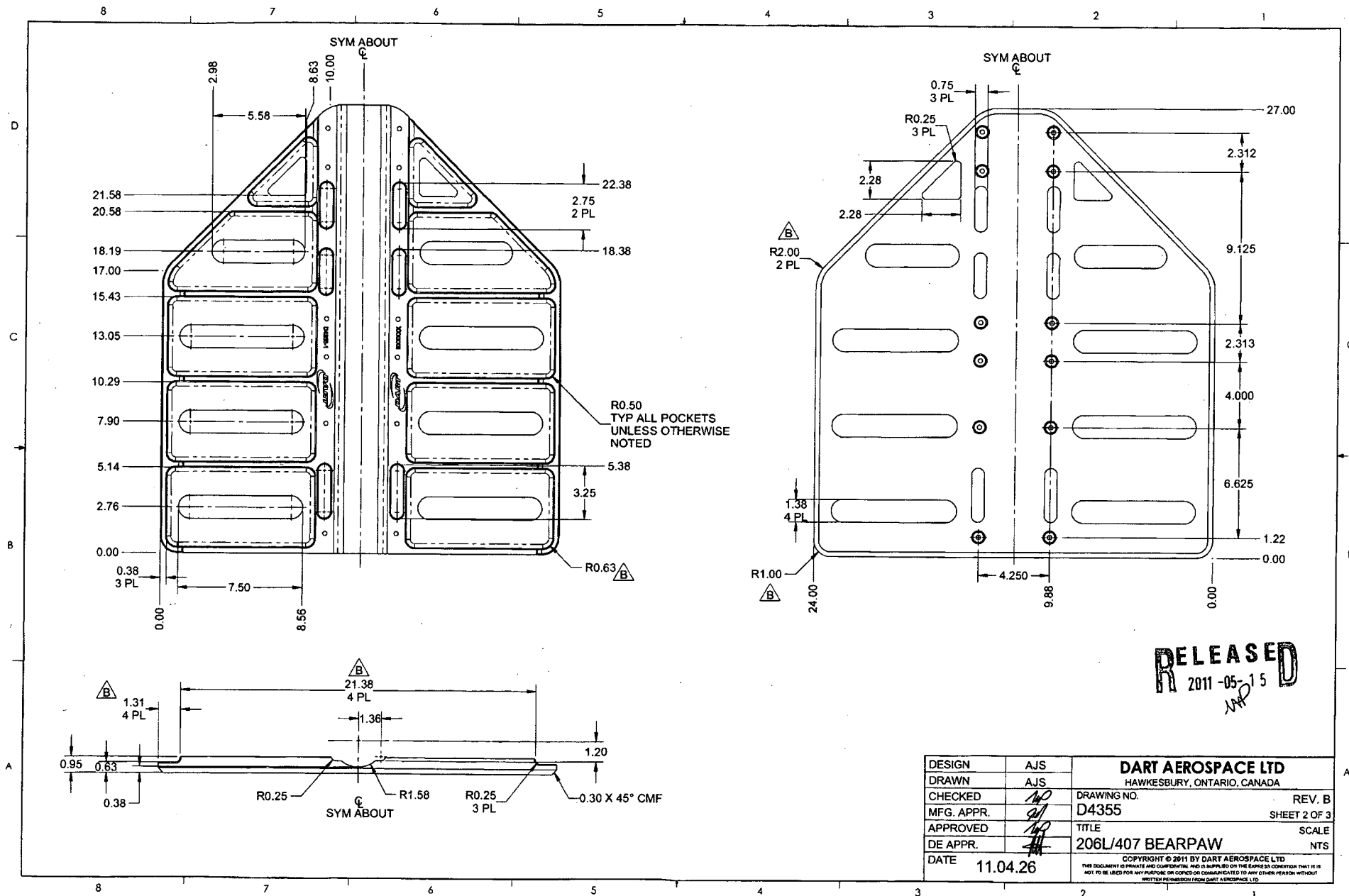
132552

RELEASED
2011-05-10

NOTES:

- 1) MATERIAL: UHMW BLACK SPEC CONTROL DRAWING D2689, 1.000 THICK.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D4355-1" AND B/N "BXXXXX" 0.010 - 0.012 DP AS SHOWN
- 7) WEIGHT: 6.88 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.003 - 0.005 DP. 

B	SHT 1 WEIGHT CORRECTED WAS 8.41 lbs. SHT 2 RIB DIMS UPDATED. ZN B4 RAD WAS 2.00. SHT 3, SECT. B-B RIB HEIGHT INCREASED. ALL SHTS DART LOGO UPDATED.	AJS	11.04.26
A	NEW ISSUE	AJS	11.03.21
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4355	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		206L/407 BEARPAW	NTS
DATE	11.04.26	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



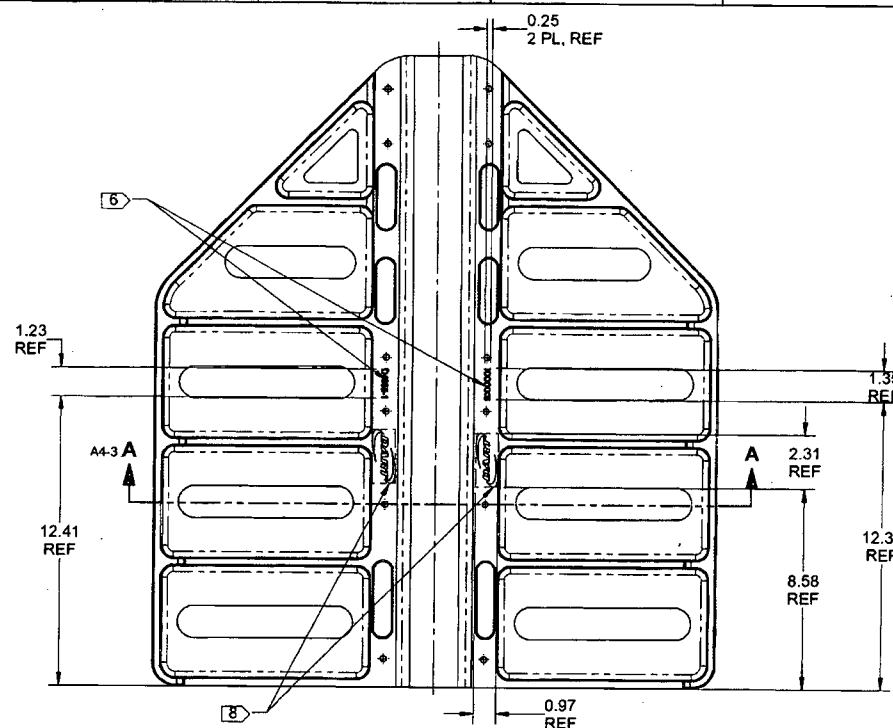
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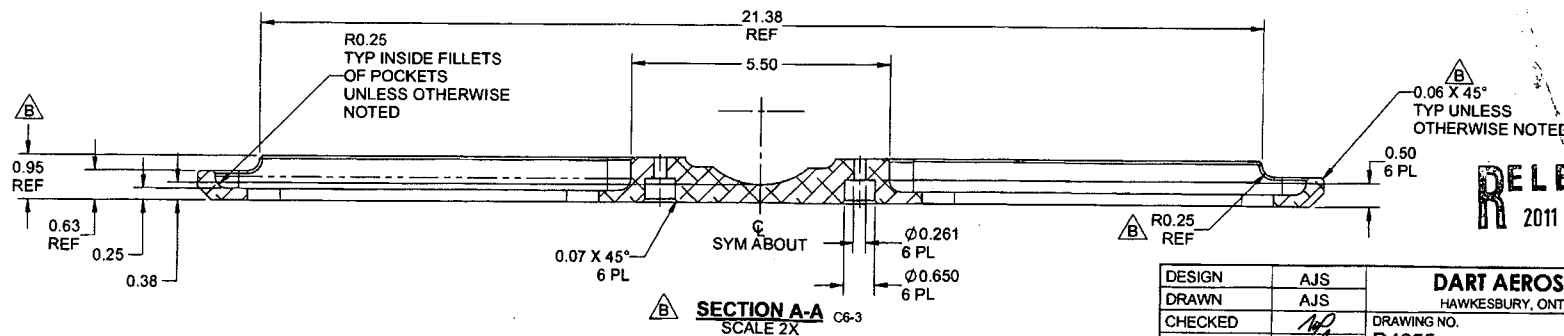
C

B

A



(SUPPLEMENTAL VIEW)



SECTION A-A
SCALE 2X

RELEASED
2011-05-15

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4355	REV. B SHEET 3 OF 3
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	206L/407 BEARPAW	NTS
DE APPR.	<i>[Signature]</i>	DATE 11.04.26	

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